

Work Order ID 147039

Friday, May 27, 2016 3:35:38 PM

147039

Page 1

Item ID: D119-796-021

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: sem Date: 16/05/27 Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D119-796-021	A
IIN-D119-796	E

JUL 21 2016

100

Pick Kit

0.00

100

Packaging

Memo

0.02

Packaging

Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paperwork

110

0.00

110

HandFinish

Memo

6.97

Hand Finishing

ASSEMBLE AS PER DWG AND NOTES 8,9,10,11

ASSEMBLE WITH PROSEAL BATCH: 14135043

2-INSTALL DECAL D2729-4

DAS
76
9-8914 16/05/05

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 16 9-89
120						(PL)			
QC	Memo	0.50							16/08/16
Quality Control									
130	Identify as per dwg & Stock Location: <i>Shi</i>	0.00							
130									
Packaging	Memo	0.25							
Packaging	Identify and pack for shipping as per PPP D119-796-021								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

SH AUG 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

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Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD IPP
REV:B 15.08.25 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-646-041		Manufactured	No			110	Each	0.0000	2	2			DAS 36 9-89
D119-646-041						B149013 (1X)		B147829 (1X)	**			16/08/05	
Replacement Skidtube with Wearpads, Fits LH or RH													
D119-796-151		Manufactured	No			110	Each	1.0000	1	1			DAS 36 9-89
D119-796-151									**			16/08/05	
FWD Crosstube Installation with Step (no hardware)													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				143553		1							
D119-796-251		Manufactured	No			110	Each	2.0000	1	1			DAS 36 9-89
D119-796-251									**			16/08/05	
AFT Crosstube Installation with Step (no hardware)													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		2							
				145044		1							
				145045		1							
D2652		Manufactured	No			110	Each	127.0000	48	48			DAS 36 9-89
D2652									**			147599x44	
Bushing												145959x5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		45							
				31985		45							
				ST009		82							
				141609		82							

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3407-041	Manufactured	No	110	Each	5.0000	2	2	
D3407-041								
Tow Ring								

145422x1 147290x1

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st530	5	
145210	5	

D3417-5	Manufactured	No	110	Each	133.0000	4	4	
D3417-5								
Washer								

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST035	12	
140183	12	
ST038A	121	
145908	121	

D3456-1	Manufactured	No	110	Each	99.0000	2	2	
D3456-1								
Washer								

147066

DAS
6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	7	
25701	7	
ST038	42	
141989	42	
ST038A	50	
144158	50	

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3672-3

Manufactured No

110

Each

949.0000

48

48

D3672-3

Washer, Phenolic

146277

DAS

6
9-89

Location

Loc Qty

Loc Code

FG

100

133083

52

134449

48

FP001

213

132639

213

ST049

136

139583

136

ST051A

500

142571

500

D3672-7

Manufactured No

110

Each

934.0000

48

48

D3672-7

Washer, Phenolic

Location

Loc Qty

Loc Code

FG

40

129987

25

133986

15

ST049

394

134786

394

ST051A

500

142572

500

48

D3883-1

Manufactured No

110

Each

0.0000

2

2

D3883-1

Saddle, Outboard LH

147713

DAS

6
9-89

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

D3883-2

Manufactured No

110

Each

24.0000

2

2

D3883-2

Saddle, Outboard RH

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

24

142486

12

142792

5

144927

7

D3884-1

Manufactured No

110

Each

25.0000

2

2

D3884-1

Saddle, Inboard LH

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

25

142461

10

142674

10

144928

5

D3884-2

Manufactured No

110

Each

17.0000

2

2

D3884-2

Saddle, Inboard RH

DAS
6
9-89

Location

Loc Qty

Loc Code

ST404

17

142471

12

142761

5

D3886-041

Manufactured No

110

Each

6.0000

4

4

D3886-041

Lug Assembly

DAS
6
9-89

Location

Loc Qty

Loc Code

ST528

6

142776

6

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																										
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Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

348.0000

8

8

AN3C46A

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

FG

10

122843

10

OVER002

280

134795

70

M133917

70

M134591

70

M134794

70

ST346

58

M132522

34

M133332

24

AN3C50A

Purchased

No

110

Each

53.0000

16

16

AN3C50A

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

ST346

53

M133606

1

M133842

2

M134494

50

135057

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By: _____	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

AN4C6A	Purchased	No	110	Each	431.0000	24	24		DAS
AN4C6A								**	6
Bolt									9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	14	
103344	4	
121657	10	
OVER002	150	
m134861	150	
ST345	267	
m134502	267	

MS21043-3	Purchased	No	110	Each	1,175.000	24	24		DAS
MS21043-3								**	6
Nut									9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	80	
103691	80	
FP001	11	
m130673	11	
GA	347	
m133990	347	
OVER007	400	
m134861	400	
ST302	231	
m134502	231	
ST304	106	
m131340	106	

JUL 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
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LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due	OTHER : _____							

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Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No 110 Each 1,020.000 26 26

MS21043-4

Nut

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	40	
104603	40	
GA	17	
m132803	17	
OVER007	300	
m134502	300	
ST302	663	
m133769	12	
m134249	51	
m134634	300	
m134754	300	

26

MS21043-5 Purchased No 110 Each 184.0000 8 8

MS21043-5

Nut

138/57

DAS
6
9-89

Location	Loc Qty	Loc Code
FG	20	
101418	20	
GA	76	
116548	76	
ST302	88	
m132382	9	
m134502	79	

MS21250-05048 Purchased No 110 Each 30.0000 8 8

MS21250-05048

Bolt (use MS21250-05-048)

134973

Location	Loc Qty	Loc Code
ST295	30	
m133694	30	

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DAS
6
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

110

Each

3,945.000

24

24

DAS

NAS1149C0332R

6
9-89

WASHER

Location

Loc Qty

Loc Code

FP001

1766

m132930

1004

m134073

128

m134574

634

GA

141

m133284

141

ST266

2038

m134654

38

m134736

2000

NAS1149C0432R

Purchased

No

110

Each

1,509.000

48

48

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

1272

m125807

427

m134676

845

ST266

237

m134073

237

NAS1149C0532R

Purchased

No

110

Each

393.0000

16

16

NAS1149C0532R

WASHER

Location

Loc Qty

Loc Code

GA

60

116513

60

ST266

333

m133031

133

m134756

200

DAS
6
9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By Lead hand/ Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Page 9

Friday, May 27, 2016 3:35:43 PM

Work Order ID: 147039

147039

Parent Item: D119-796-021

D119-796-021

Parent Item Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection

Start Date: 6/16/2016

Required Date: 7/15/2016

Start Qty: 1.00

Required Qty: 1.00

139x89x35crate

Purchased

No

110

Each

5.0000

1

1

DAS

36

9-89

139x89x35crate

Agusta Crate

MS21920-28

Purchased

No

Each

29.0000

2

DAS

6

JUL 26 2016

MS21920-28

Clamp

Location

Loc Qty

Loc Code

FG

1

105884

1

LG051

1

M132169

1

LG057

27

M134130

2

M134590

25

Friday, May 27, 2016 3:35:43 PM

Shop Packet Print

Page 9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By 	
								Lead hand / Supervisor Approval Verification 	
								QC / QA Coordinator Approval 	

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								☐ OTHER : _____																																							

B

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
- 7) WEIGHT: 122.7 LBS

A.P. ECHIS-570

APPROVED

A

Lm 16/05/27

MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

AN3C50A BOLT
D3672-7 WASHER
D2652 BUSHING
4 PL
10

D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

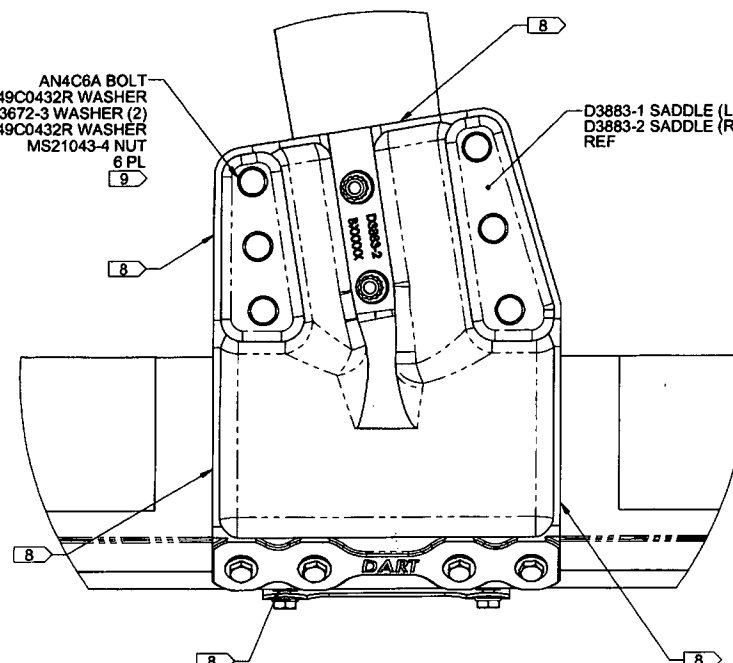
D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

DETAIL A
4 PL



AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF



DETAIL A



NOTES:

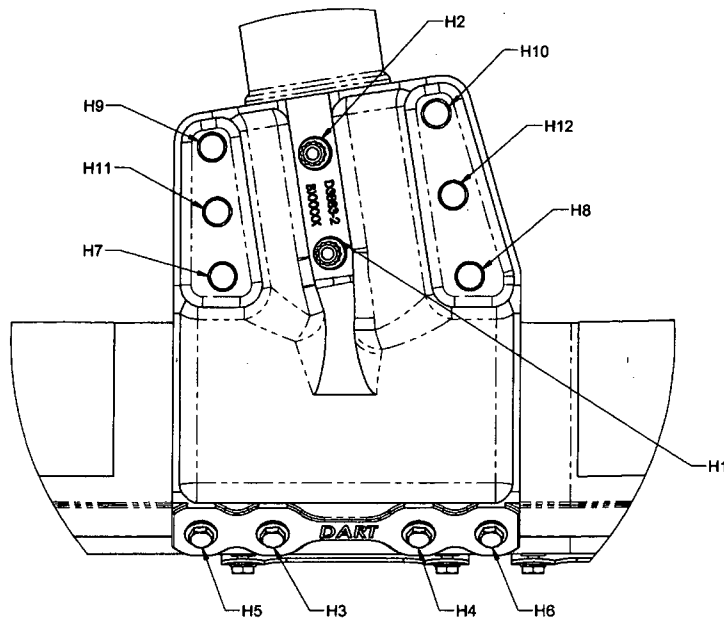
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

RELEASED

2015 MAY 12
A.P. EW 15-570

APPROVED

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C6A	50-70 IN-LBS (5.7 - 7.9 N-m)

RELEASED

2015 MAY 12
A.R. EW 15-570

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DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
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